



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW6205G06131-3G-PO

Job Sheet 191255



Part No: RBW6205G06131-3G-PO **Job Qty:** 4 pcs

Part Name: Main Rotor Pitch Control Lever Expander



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 2/25/19

Job Tracking No:

Due Date: 4/29/19

Created By: Patrick Lussier

Type: Stock

Description:

Note: DWG RBW6205G06131-3G Rev. D IPP Rev. A 18.09.21 New issue DP Verify DD/ IPP Rev. B 18.09.24 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Purchasing	4 pcs	4/29/19	4/29/19	0.00	0.00	Purchasing - 1	APR 01 2019
							Purchasing - 2	
							Purchasing - 3	
110	Packaging 2-1 - Receive - B4B	4 pcs	4/29/19	4/29/19	0.00	0.00	Packaging 2 - 1 - B4B	APR 01 2019
							Packaging 2 - 2 - B4B	
							Packaging 2 - 3 - B4B	
							Packaging 2 - 5 - B4B	
							Packaging 2 - 4 - B4B	
							Packaging 2 - 6 - B4B	
							Packaging 2 - 7 - B4B	
							Packaging 2 - 8 - B4B	
							Packaging 2 - 9 - B4B	
							Packaging 2 - 10 - B4B	
							Packaging 2 - 11 - B4B	
							Packaging 2 - 12 - B4B	
							Packaging 2 - 13 - B4B	
							Packaging 2 - 14 - B4B	
							Packaging 2 - 15 - B4B	
							Packaging 2 - 16 - B4B	
							Packaging 2 - 17 - B4B	
							Packaging 2 - 18 - B4B	
							Packaging 2 - 19 - B4B	
							Packaging 2 - 20 - B4B	
							Packaging 2 - 21 - B4B	
							Packaging 2 - 22 - B4B	
							Packaging 2 - 23 - B4B	
							Packaging 2 - 24 - B4B	
							Packaging 2 - 25 - B4B	
							Packaging 2 - 26 - B4B	
							Packaging 2 - 27 - B4B	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S167983



Part: RBW6205G06131-3G

Job No: 191255

Serial No/Batch: S167983

Revision: D

Inspector:

Exp Date:

Instructions:

Date: 04/01/19

Plex 2/25/19 1:19 PM dart.Lussier.Patrick

					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
120	QC 6	4 pcs	4/29/19	0.00 0.00	QC 6 - 42	DAS DAS
					QC 6 - 9	APR 0 2 2019 40 9
					QC 6 - 68	9-89 9-89
					QC 6 - 61	
130	Small Fab - 2 - B4B	4 pcs	4/29/19	0.00 2.00	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	MCC
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
140	QC 5	4 pcs	4/29/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 42	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	DAS DAS
					QC 5 - 9	APR 0 3 2019 40 9-89
					QC 5 - 50	
					QC 5 - 30	
150	Packaging 3-1 - Stock - B4B	4 pcs	4/29/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160 QC 21 - FG	4 pcs	4/29/19	0.00 0.00	QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-88

RBOOZA

APR 03 2019

Part Op 100 - Purchasing (Purchasing) Issue PO to ARROW TECH MACHINE WORKS P/O: _____ MANUFACTURE

Descriptions: RBW6205G06131-3G AS PER DWG -Certificate of conformity is required

110 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)

120 - (QC6- All purchased or subcontracted products)

130 - (Small Fab) 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case APP-1400-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

140 - (QC5- Inspect part completeness to step on W/O)

150 - (Identify as per dwg & Stock Location: _____)

160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6205G06131-3GP	Main Rotor Pitch Control Lever Expander	4 pcs (1 ea)	100-Purchasing	5167982
97524A032	Sealing Blind Rivet	16 Ea (4 ea)	130-Small Fab - 2 - B4B	5145165
APP-1120-E	Case	4 Ea (1 ea)	130-Small Fab - 2 - B4B	5163216
RB41011	Dart Tooling Placard, Aluminum	4 Ea (1 ea)	130-Small Fab - 2 - B4B	5021040
RBW6205G06131-3G-2	Bottom Foam use in case APP-1120-E	4 Ea (1 ea)	130-Small Fab - 2 - B4B	5163218
RBW6205G06131-3G-3	Top Foam use in case APP-1120-E	4 Ea (1 ea)	130-Small Fab - 2 - B4B	5163217

Job Allocations

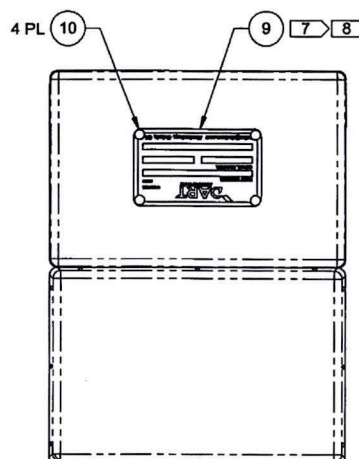
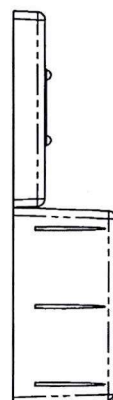
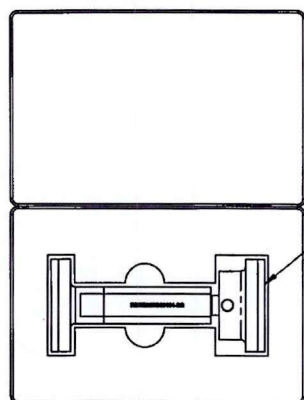
Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	RBW6205G06131-3GP	4	2	0
130-Small Fab - 2 - B4B	97524A032	16	430	0
	APP-1120-E	4	11	0
	RB41011	4	403	0
	RBW6205G06131-3G-2	4	2	0
	RBW6205G06131-3G-3	4	2	0

Part Specifications

Specifications could not be found.

Plex 2/25/19 1:19 PM dart.Lussier.Patrick

ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6205G06131-3G-1	PACKAGING ASSY
-4	1	RBW6205G06131-3G-4	EXPANDER ASSY
9	1	RB41011	DART PLACARD
10	4	McMaster#97524A032 OR EQUIV.	ALUMINUM SEALING BLIND RIVETS 1/8" DIA. x 0.425" LG.



RBW6205G06131-3G M/R PITCH CONTROL LEVER EXPANDER

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A

- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: ENGRAVE THE TOOL P/N & S/N ON THE DART PLACARD WHERE INDICATED
- 8) INSTALL THE DART PLACARD ONTO THE TOP OF THE CASE IN AVAILABLE AREA USING ALUMINIUM POP RIVETS
- 9) HOT GLUE THE TOP AND BOTTOM FOAM INTO THE CASE

D	4 DIMENSION 0.52 CHANGED FOR 0.520 +/-0.005 7 DIMENSION 0.220 CHANGED FOR 0.220 +/-0.005/-0.005 0.594 CHANGED FOR 0.61 +/-0.010/-0.010, DIMENSION 3/8-16 UNC THRU CHANGED FOR 3/8-16 UNC 3PL THRU	18-811	VM
C	UPDATED DRAWING TEMPLATE, CHD DASH NUMBERS, REMOVED -11 SPRING PIN MCMASTER-CARRIP#0692A741, ADDED SPRING PLUNGER McMaster#3126A149 -1 ADDED PACKAGING ASSY -2 WAS -15 IS -2 -3 WAS -17 IS -3 -4 WAS -1 IS -4 -5 WAS -3 IS -5, FINISH WAS ZINC PLATE IS BLACK OXIDE -6 WAS -5 IS -6, FINISH WAS ZINC PLATE IS BLACK OXIDE -7 CHD DIM WAS Ø0.94 IS Ø1.75, ADDED 3 HOLES 3/8-16 EQL SPC. FINISH WAS ZINC PLATE IS BLACK OXIDE -8 WAS -9 IS -8		KPT
2	-3, -5, -7 CHD FINISH WAS CAD PLATE YELLOW IS ZINC PLATE SPEC. ASTM B633 TYPE 1 SC 2. -3 DELETED DETAIL B, ADDED MIN. UNDERCUT NOTE, CHD DIM WAS .50 IS 2X .60, CHD THREAD CALL OUT WAS 9/16-18 UNF -2A, WAS 3X 10-32 UNF THRU ALL IS 3X 10-32 UNF -2B THRU ALL. -5 CHD THREAD CALLOUT WAS 9/16-18 UNF 2.00 IS 9/16-18 UNF -2B 2.00. -7 ADDED DIM .220, CHD THREAD CALL OUT WAS 3X 10-32 UNF THRU ALL IS 3X 10-32 UNF -2B THRU ALL. -9 CHD DIM WAS (.188) IS .19, CHD MATERIAL WAS NYLON/DELRIIN IS NYLON/DELRIIN/ACETAL. -15, -17 CHD DWG. TO SHEET METAL TOLERANCE, CHD MATERIAL AND VENDOR WAS Y20 BLACK I.R. SPECIALTY IS ETHAFOAM 220, BLACK (CASE SOLUTIONS). -15 CHD DIM WAS 4.83 IS 4.93, WAS 7.34 IS 7.43, WAS 2.66 IS 2.55, WAS 4X R.08 IS 4X R.14, DELETED DIM 4X R.08, ADDED DIMS 4X .50, 4X 45°. -17 CHD DIM WAS 4.67 IS 4.93, WAS 7.14 IS 7.43, WAS 4X R.13 IS 4X R.14, WAS .45 IS .72, WAS 4X 1° IS 4X 2°, ADDED -23, -25 DELETED.		RJC
1	RELEASED FOR PRODUCTION		DPD
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	VM	TOOL PART #	REV D
MFG. APPR.	FK	RBW6205G06131-3G	SHEET 1 OF 9
APPROVED	VK	TITLE	SCALE
		M/R PITCH CONTROL LEVER EXPANDER	NTS
DATE	9/24/2018	COPYRIGHT © 2018 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO042703**



Supplier: ARR002-VU
Arrow Tech Machine Works
29751 E. Enid Road,
Unit C
Eugene, OR 97402 USA
Phone: 541-780-6938
Fax: 458-215-4938

PO No: PO042703

PO Date: 2/25/19

Due Date: 4/29/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Phone:

Ship To:

Pymt Terms: Net 30

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (USD)	Extended Price
1	191247	RBW6305G01232-3GP			Gimbal Torque Tube Bushing Remover REV 3	Firmed	-	4/29/19	2 Ea	0 Ea	2 Ea	\$708.34/Ea	\$1,416.68
2	191252	RBW6205G13231-3GP			Arm Assembly As Per Dwg RBW6205G13231-3G Rev. 1	Firmed	-	4/29/19	9 Ea	0 Ea	9 Ea	\$298.00/Ea	\$2,682.00
3	191253	RBW6305G00232-3GP			Gimbal Torque Tube Bushing Installer REV 2	Firmed	-	4/29/19	2 Ea	0 Ea	2 Ea	\$708.75/Ea	\$1,417.50
4	191255	RBW6205G06131-3GP			Main Rotor Pitch Control Lever Expander REV D	Firmed	-	4/29/19	4 pcs	0 pcs	4 pcs	\$913.63/pcs	\$3,654.52
5	191258	RBW6205G03731-3GP			Trim Tab Bending Gauge Assembly REV 4	Firmed	-	4/29/19	3 Ea	0 Ea	3 Ea	\$1,204.00/Ea	\$3,612.00
												Grand Total: \$12,782.70	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

PO042703



Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY

A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)

A012 CHEMICAL AND PHYSICAL TEST REPORTS

A016 PERSONNEL QUALIFICATION

A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM

A042 DART NOTIFICATION BY SUPPLIER

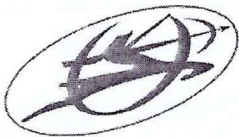
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "P. Lussier".

Plex 2/25/19 2:20 PM dart.Lussier.Patrick



**PHGE Machineworks dba
Arrowtech Machineworks**
29751 E Enid Rd. Unit C
Eugene, Oregon 97402
Phone: (541) 780-6938
Fax: (458) 215-4938

Packing Slip

NO. 491

Date: 3/28/2019
PO Ref: 042703
Ship via: Fedex Priority

Bill To:
Dart Aerospace
1270 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K7

Ship To:
Dart Aerospace
1271 Aberdeen St. Hawkesbury, ON
CANADA K6A 1K8

Qty	Item	Part No.
9 ✓	ARM ASSEMBLY	✓ RBW6205G13231-3G
4 ✓	M/R PITCH CONTROL LEVER EXPANDER	✓ RBW6205G06131-3G
2 ✓	GIMBAL TORQUE TUBE BUSHING INSTALLER	✓ RBW6305G00232-3G
2 ✓	GIMBAL TORQUE TUBE BUSHING REMOVER	✓ RBW6305G01232-3G

Received by: _____

Packaged by: J.M.L.

Checked by: AdP.

Thank You



ARROW TECH MACHINE WORKS

Certificate of Conformance

Your Purchase Order No:042703 ✓

Dated: 3/28/2019

Our Order / Job No:042703-4AWT

Order Qty: 4 ✓

Part Name: MAIN ROTOR PITCH CONTROL LEVER EXPANDER

Part Number: RBW6205G06131-3G ✓

Lot Size: N/A

Ship Date: 3/28/2019

DAS
40
9-89

We certify that these parts shipped to you are of domestic or international manufacture and conform to all requirements of the Purchase Order. These parts have been manufactured and inspected in accordance with all required specifications, instructions and drawings. Any applicable specifications are listed below:

Drawing Number: RBW6205G06131-3G

Rev: D

Material Size and Type: -5, -6, -7/4140 Q & T STEEL; -8/Delrin

Material Specifications: STEEL: ASTM A108, ASTM A29; DELERIN: D6100

Heat Treatment: (28-32 HRC)

Plating/Finish: BLACK OXIDE: QMSI-6.2 B.O. REV-D

Mercury Contamination: The material used to process this order has not come in contact with mercury or mercury bearing instruments.

Date: 03/28/19

Signed: 

PHGE Machine Works LLC dba Arrow Tech Machine Works
29751 E. Enid Rd. Unit C Eugene, Oregon 97402
Main: (541) 780-6938 | Fax: (458) 215-4938
www.atechmachineworks.com